

Work Order ID 141112

Wednesday, January 27, 2016 7:39:09 AM

141112

Page 1

Item ID: D205-770-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Engine Mounts

Stop

NS2

Start Date: 1/27/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/3/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ Date: JAN 27 2016

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

IIN D205-770

D

DAS

6

9-89

MLJ

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and create labels per PPP D205-770-011 CHG006

DAS

27

9-89

JAN 27 2016

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

JAN 26 2016

DAS

6

9-89

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

VERIFY ASSEMBLY OF TRIPOD

DAS

27

JAN 27 2016

DAS

28

9-89

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 141112***141112***

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Item ID: D205-770-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Replacement Engine Mounts

Stop

NS2

Start Date: 1/27/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 2/3/2016 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00

130

Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D205-770-011
Location: FG028DAS
27
9-89

JAN 27 2016

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

MLJ

JAN 27 2016

JAN 27 2016

MLJ

DQA: _____ Date: _____



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		OTHER : ☐							

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141112

D205-770-011

Required Date: 2/3/2016

Required Qty: 1.00

Comments: IPP Rev:A new issue ECN1165p 08-03-31 DD verified by:EC IPP REV:B
11.12.05 PER ECN11-676 DD VERF:EC IPP REV:C 13.01.24
PER ECN12-693 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3684-043		Manufactured	No			110	Each	2.0000	1	1			
D3684-043									**				DAS 6 9-89
Mount Assembly													DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST232				2					
				137083				2					
D3684-045		Manufactured	No			110	Each	1.0000	1	1			
D3684-045									**				DAS 6 9-89
Inboard Leg Assembly													DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST231a				1					
				128408				1					
D3685-041		Manufactured	No			110	Each	1.0000	1	1			
D3685-041									**				DAS 6 9-89
Bipod Mount Assembly													DAS 28 9-89
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST231B				1					
				132947				1					
D3686-041		Manufactured	No			110	Each	0.0000	1	1			
D3686-041									**				DAS 6 9-89
Mohopod Assembly										1406			DAS 28 9-89

JAN 20 2016

DAS
27
9-89

DQA: _____ Date: _____



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Description Work Order Deviation				Disposition					
Root Cause		FAULT CATEGORY							
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong				
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions				
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance				
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect				
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing				
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved				
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing				
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Mislabeled	☐ Finish				
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread				
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence				
Past Expiry Date ☐	☐ Manufacturing Process								
Misidentified ☐	☐ Past Due								
		OTHER : ☐							

Picklist Print

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Work Order ID: 141112

141112

Parent Item: D205-770-011

D205-770-011

Parent Item Name: Replacement Engine Mounts

Start Date: 1/27/2016

Required Date: 2/3/2016

Start Qty: 1.00

Required Qty: 1.00

HL32PB8-14

Purchased

No

110

Each

107.0000

2 2

HI 32PB8-14

Replacement Hi-Lok Pin

**

DAS

6

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

ST554

107

ST554

125436

2

m128179

5

m128454

100

DAS

27

9-89

HL86-8

Purchased

No

110

Each

118.0000

2 2

HI 86-8

Collar

**

DAS

6

9-89

Location

Loc Qty

Loc Code

st555

118

ST555

m127815

18

m131803

100

DAS

28

9-89

13-420

Purchased

No

110

Each

23.0000

1 1

13-420

Piloted Drill

**

DAS

6

9-89

DAS

28

9-89

Location

Loc Qty

Loc Code

ST562

23

ST562

124728

23

ST562

110

Each

18.0000

1 1

44-300

Purchased

No

44-300

Step Reamer

**

DAS

6

9-89

Location

Loc Qty

Loc Code

ST562

18

ST562

124728

18

DAS

27

9-89

JAN 27 2016

DAS

28

9-89

DQA: _____ Date: _____



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		OTHER : ☐							

4. WEIGHT AND BALANCE

The following is the net weight increase associated with the D205-770-011 Kit.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-770-011	14.6 lb	-3.5 in	-51.1 in-lb	190.0 in	2774 in-lb
Replacement Engine Mount Kit	6.62 kg	-0.09 m	-0.6 m-kg	4.83 m	31.97 m-kg

5. PARTS LIST

Qty	Part Number	Description
X	D205-770-011	REPLACEMENT ENGINE MOUNT KIT
1	D3684-043	MOUNT ASSEMBLY
1	D3684-045	INBOARD LEG ASSEMBLY
1	D3685-041	BIPOD MOUNT ASSEMBLY
1	D3686-041	MONOPOD ASSEMBLY
2	HL32PB8-14	HI-LOK PIN
2	HL86-8	HI-LOK COLLAR
1	13-420	PILOTED DRILL (0.2314 dia. w/ 0.2158 pilot)
1	44-300	STEP REAMER (0.2470 dia. w/ 0.2314 pilot)